

Date: Tuesday, 11/29/2005 7:06:45 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 25067

Estimate Number : 11110

P.O. Number : N/A

This Issue : 11/29/2005 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : PURCHASED PARTS

Previous Run : N/A

Part Number : D33047

Drawing Number : D3304 REV B

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 12/13/2005

Qty: 20 Um: Each

Written By : EST REV: B KJ.

Checked & Approved By : SEE ABOVE

Comment : Created By Auto Work Order

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 PG

PURCHASING



D 33047 F



Comment: PURCHASING

Issue P/O: 1000000196 05/11/30

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3304

Possible Supplier: GFI & Industrial Laser

Material release note is required

Tools:

2.0 D33045F

Bracket



Comment: Qty.: 1.0000 U(s)/Unit Total: 20.0000 U(s)
Bracket

Tools:

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

DL 05/12/30 20

Tools:

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Tools:

06-01-03

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06-01-31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
<u>06-01-03</u>	<u>5</u>	holes not exactly made to Dwg. 0.010" under due to laser cut.	<u>[Signature]</u>	Finish holes as per Dwg.	<u>[Signature]</u> <u>06-01-31</u>	<u>[Signature]</u> <u>06-01-31</u>	<u>[Signature]</u> <u>06-01-31</u>	<u>[Signature]</u> <u>06-12-03</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25067

Part Number: D33047

Job Number: 

Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

DL 06/01/06 21

Tools:

6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
1-Deburr
2-Form as per Dwg D3304
3-Tumble Paint

SB 06/01/17 21
DL 06/01/23 (21) (P10)

Tools:

7.0	QC5	INSPECT WORK TO CURRENT STEP
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J 06/01/17 21

Comment: INSPECT WORK TO CURRENT STEP

Tools:

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 414

06/01/24 (21)

Tools:

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

SUR 06/01/26 (21)

DD 06/01/25 (21)

Tools:

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-17	6	No tumble req'd. parts to be welded. remove tumble. <i>permanent change</i>	<i>RE</i>	06.01.17		<i>h</i> 06-01-17	<i>2</i> 06-01-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *h* Date: *06/01/25*
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

90229754

YIH MAU CORP.

INVOICE NO.
COMMODITY:

FOUR CLASS
PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304 NO.4 (SIC)
FINISH, WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.

SPECIFICATION:
CUSTOMER:

INTEGRIS METALS LTD

1. 鹿耳門港尾村新順安路345號
345, SHUN AN RD, LI CHU HSANG
KAO-HSIUNG TAIWAN R.O.C.
TEL: (07) 872185 FAX: (07) 872006
CERTIFICATE NO: 9011192
DATE OF ISSUE: 1/24/2004

CUSTOMER :		INTERFIS METALS LTD				Physical Properties Tensile Test GL-50 m/m					Chemical Composition (%)							
(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	SI x100	Mn x100	P x100	S x100	NE x100	Cr x100	N x100
		KGS	LBS															
AISI 304 2B (7425-4228)																		
24GA/48"X120"	1	1,465	3,230	YU231320	3AS44463B-21	258	665	56	81	156	4.6	51	119	24	2	804	1821	2.7
24GA/48"X120"	1	1,464	3,228	YU231320	3AS44463B-22	258	665	56	81	156	4.6	51	119	24	2	804	1821	2.7
(7425-5860)																		
22GA/48"X96"	1	1,464	3,228	YU230510	3S837600B-61	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
(7425-5850)																		
22GA/48"X120"	1	1,375	3,031	YU230510	3S837600B-52	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
(7425-5850)																		
18GA/48"X96"	1	1,445	3,186	YU134975	3AS43434A-1	312	666	61	82	161	4.1	49	112	24	2	809	1821	2.8
(7425-2884)																		
18GA/48"X96"	1	1,497	3,300	YU231066	3AS42732-4	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
(7425-2619)																		
18GA/48"X120"	1	1,453	3,203	YU231066	3AS42732-5	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA/48"X120"	1	1,455	3,208	YU231066	3AS42732-6	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
(7425-5164)																		
16GA/48"X120"	1	1,423	3,137	YU231143	3AS42886A-6	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,424	3,139	YU231143	3AS42886A-7	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,420	3,131	YU231143	3AS42886B-1	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
(7425-7949)																		
16GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
16GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
(7425-8053)																		
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-3	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
(7425-8244)																		
14GA/60"X96"	1	1,446	3,188	YU135202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
(7425-8277)																		
14GA/60"X120"	1	1,405	3,097	YU135202	3AS45623A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA/60"X120"	1	1,540	3,395	YU135202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
18		25,998	57,327															
NO MERCURY CONTAMINATION Real test used for all Heat NO.																		

REMARK: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

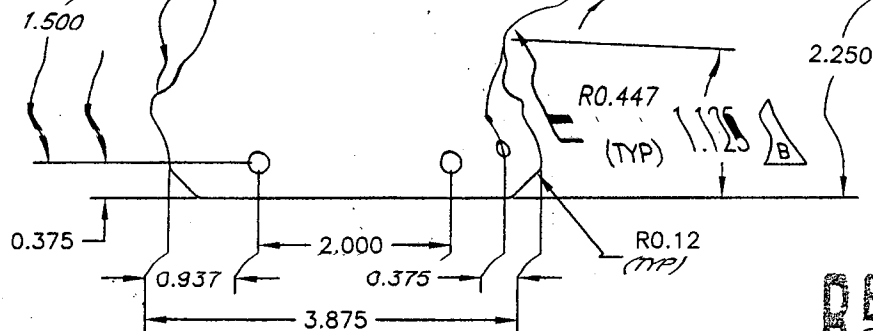
Brand tested good for all Heat NO.
PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A362R, ASME SA240, Q35766D.

YIH MAU CORP.

in Kim Hing
Manager of Quality Assurance Section

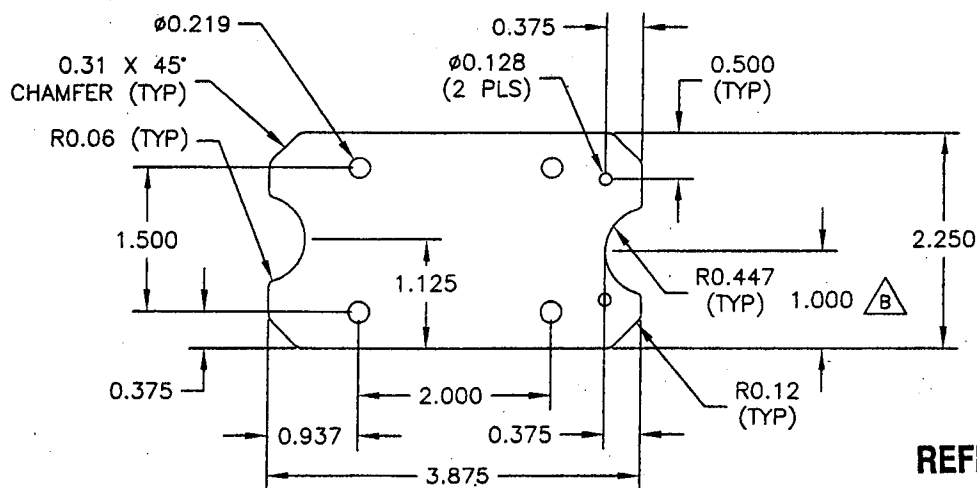
2094 304 4455
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206:01:03
266 196



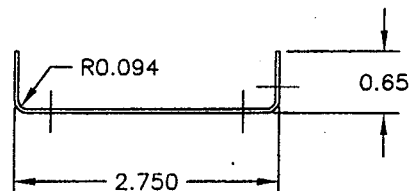
D3304-5 FLAT PATTERN

RELEASED
05-08-11



D3304-7/-8 FLAT PATTERN

REFERENCE ONLY



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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